

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010712**Date Inspected:** 04-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** As identified below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 13-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 11CW Lifting Lug weld, SSD14A-PP101-235. ZPMC welder was identified as 058551. ZPMC QC is identified as Guo Xing Hui. ZPMC CWI was identified as Lv Li Qing The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-U5-F.

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 11CW Lifting Lug weld, SSD14A-PP103-246. ZPMC welder was identified as 055491. ZPMC QC is identified as Guo Xing Hui. ZPMC CWI was identified as Lv Li Qing The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-U4b-F.

North of Blast Shop 1-

Shielded Metal Arc Welding (SMAW) of OBG segment 7CW deck panel DP116A to 278A weld, SEG037*-010. ZPMC welder was identified as 066326. ZPMC QC is identified as Wang Xiang Pin. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-4G(4F)-Repair.

WELDING INSPECTION REPORT

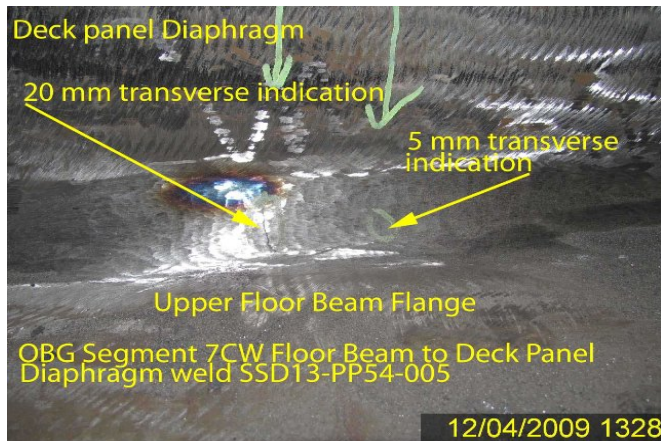
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During random visual inspection of segment 7CW deck panel diaphragm to floor beam welds. This QA inspector observed 11 transverse indications. Repair work is still in progress on the above mentioned welds. The transverse indications were shown to ZPMC QC. ZPMC QC relayed that the transverse indications would be evaluated by ZPMC MT personnel and Critical weld repair reports would be submitted by ZPMC technical department. The following indications were found during inspection:

SSD14A-PP53-005, 1 Transverse linear indication measuring 20mm
SSD14-PP53-004, 3 Transverse linear indications, 12mm, 20mm and 20mm
SSD13-PP54-005, 2 Transverse linear indications, 20mm and 5mm
SSD13-PP54-004, 2 Transverse linear indications, 12mm and 12mm
SSD14-PP55-004, 2 Transverse linear indications, 4mm and 16mm

For further information please see the attached photographs below.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
